

5/25/2007 8:37:41 AM

X Johnston

Process Sheet

Split
SB 07/06/05
Split 07/06/05

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : BRACKET

Part Number : 32861-3

Estimate Number : 12811

Part Number :

Part Number : D35921

Issue : 5/25/2007 S.O. No. :

Drawing Number : D3592 REVA

First Rev. : NC

Project Number : N/A

First Issue : 1/1 Type : SMALL / MED FAB

Drawing Revision : REVA

Previous Run : 32003

Material :

Due Date :

6/10/2007

Qty: 125 Um: Each

Written By : JohnstonChecked & Approved By : Johnston

Comment : Est Rev: A New Issue 07-03-26 ec

Additional Product

Part Number



Seq. #: Machine Or Operation:

Description :

1.0 M5061T6S125

6061-T6 .125 Sheet



Comment: Qty. 0.1460 sf(s)/Unit Total: 17.5140 sf(s)

6061-T6 .125 Sheet

Batch: M1104366M1104366

Grain must be Along 4.63

ml 070530
ml 070604125125

2.0 WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3592

Dwg Rev: #Prog Rev: #

2-Deburr if necessary

ml 070604
ml 070530125125

3.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE

ml 070604
ml 070530125125P10

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8

SECOND CHECK



Comment: SECOND CHECK

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D3592 using DT8949

SB 07/08/05 (24)
07-07-25

Process Sheet

CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Number: 32661

Part Number: D35921

Number



eq. #:

Machine Or Operation:

Description :

60

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/08 (KZY)

70

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: N/A

POSITIVE RECALL

EFFECTIVE Ad605 AUTH u

RELEASED 07.06.05 DATE 07

11.07.08.15 24

80

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.08.16.

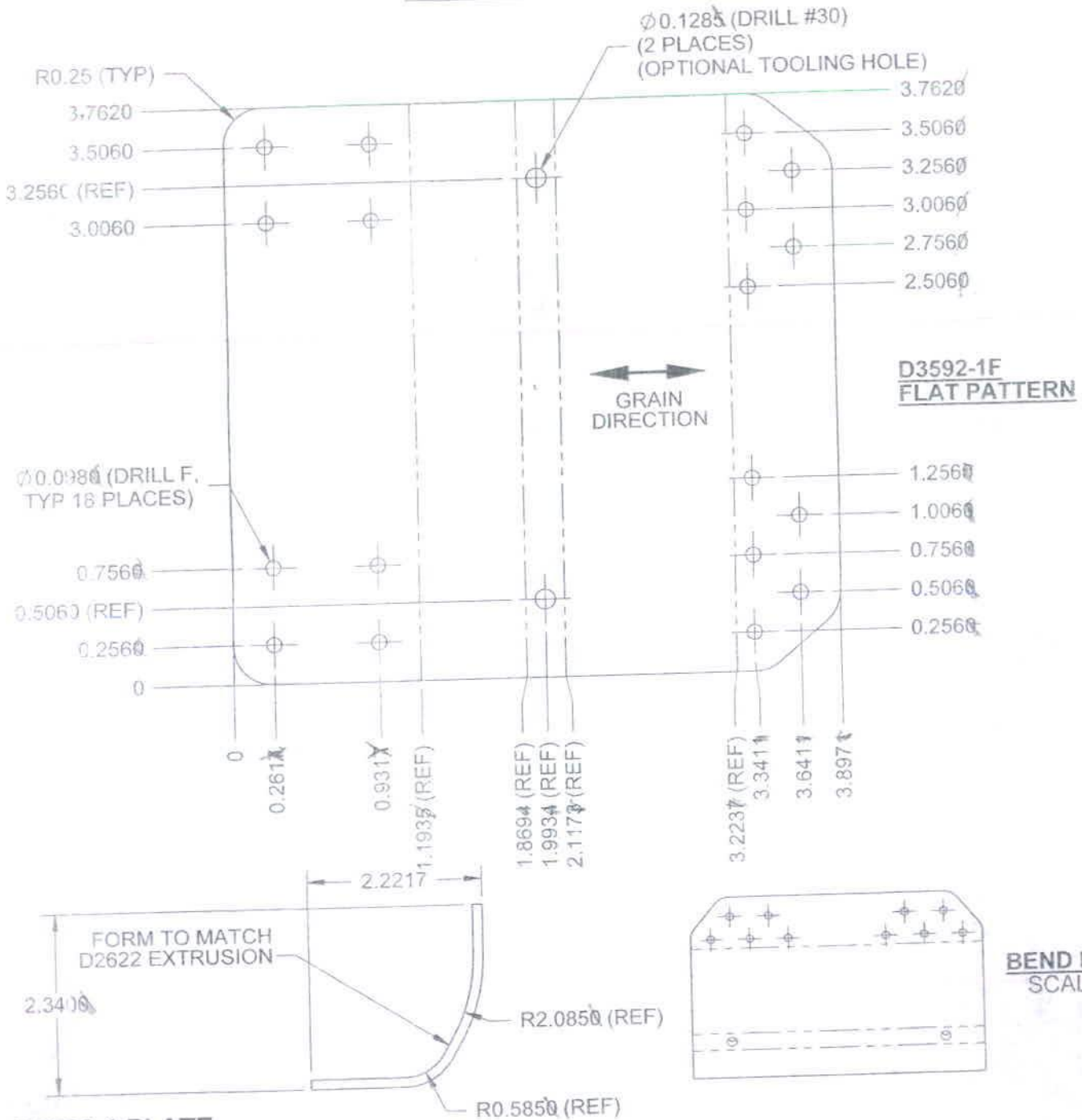
Completion



0207/08/15

PRELIMINARY ISSUE
 07.06.09

DESIGN 90	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3592	REV: A SHEET 1 OF 1
DATE 07.01.15	TITLE PLATE		SCALE 1:1
A	07.01.15	NEW ISSUE	
B	07.05.31	TOOLING HOLES ADDED	



D3592-1 PLATE

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.125" THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.125)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 MAX

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AEROSPACE LTD

Work Order: 32661

Description: Bracket

Part Number: D3592-1

Inspection Dwg: D3592 Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\phi 0.128$	$+0.005-0.001$	0.129	✓		Vern	
B $\phi 0.098$	$+0.004-0.001$	0.099	✓		Vern	
C 0.506	± 0.010	0.510	✓		Vern	
D 0.256	± 0.010	0.260	✓		Vern	
E 0.756	± 0.010	0.760	✓		Vern	
F 3.256	± 0.010	3.260	✓		Vern	
G 0.261	± 0.010	0.265	✓		Vern	
H 1.993	± 0.010	1.995	✓		Vern	
I 3.341	± 0.010	3.346	✓		Vern	
J 3.641	± 0.010	3.645	✓		Vern	
K 3.897	± 0.010	3.902	✓		Vern	
L 3.762	± 0.010	3.766	✓		Vern	
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: *mm. mm*
 Date: 07/06/04

Audited by: *MS*
 Date: 07/06/04

Prototype Approval: N/A
 Date: N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

Handwritten signature

AEROSPACE LTD

Work Order: 32661

Bracket

Part Number: D3592-1

Qwg: D3592 Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Sheet Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.098	+0.004-0.008	0.099	✓		VERN	
3.762	+/- 0.010	3.768	✓		VERN	
3.897	+/- 0.010	3.900	✓		VERN	
0.262	+/- 0.010	0.264	✓		VERN	
0.932	+/- 0.010	0.936	✓		VERN	
3.341	+/- 0.010	3.348	✓		VERN	
3.641	+/- 0.010	3.647	✓		VERN	
0.756	+/- 0.010	0.759	✓		VERN	
0.256	+/- 0.010	0.261	✓		VERN	
3.762	+/- 0.010	3.011	✓		VERN	
3.506	+/- 0.010	3.506	✓		VERN	
1.256	+/- 0.010	1.256	✓		VERN	
2.506	+/- 0.010	2.508	✓		VERN	
R0.25	+/- 0.030	R0.25	✓		Radius Gauge	

Inspected by: ml.mfl

Inspected by:

Prototype Approval:

N/A




Date: 07.05.30

Date:

Date:

N/A

Change
New IssueRevised by: Approved
KJ/PP

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07.06.05	2	REPROGRAM TO REV.B TO ADD TOLLING HOLES. SEE ATTACHED DS EMAIL FOR OK ON TOLLING HOLES				 07.06.05		
07.06.05	5	Split w/o						
07.06.05	5	Split w/o	SK	07.06.05	85	 07.06.12	 07.06.12	

Part No:

PAR #:

Fault Category:

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07.06.13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.06.04	2.0	125 parts scrap. Parts needed extra holes for the bending tool.	<i>[Signature]</i> 07.06.04 P.V.	Scrap parts, and replace to Rev. B, under Preliminary Issue. See E-mail	<i>[Signature]</i> 07.06.04	<i>[Signature]</i> 07.06.13	<i>[Signature]</i> 07.06.04 P.V.	<i>[Signature]</i> 07.06.04
			05.10.42	Scrap: destroy parts	<i>[Signature]</i> 07.06.04	SP 07.06.04	05.10.42	

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07/08/08	5	Split a/o	SB	07/08/08	24			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

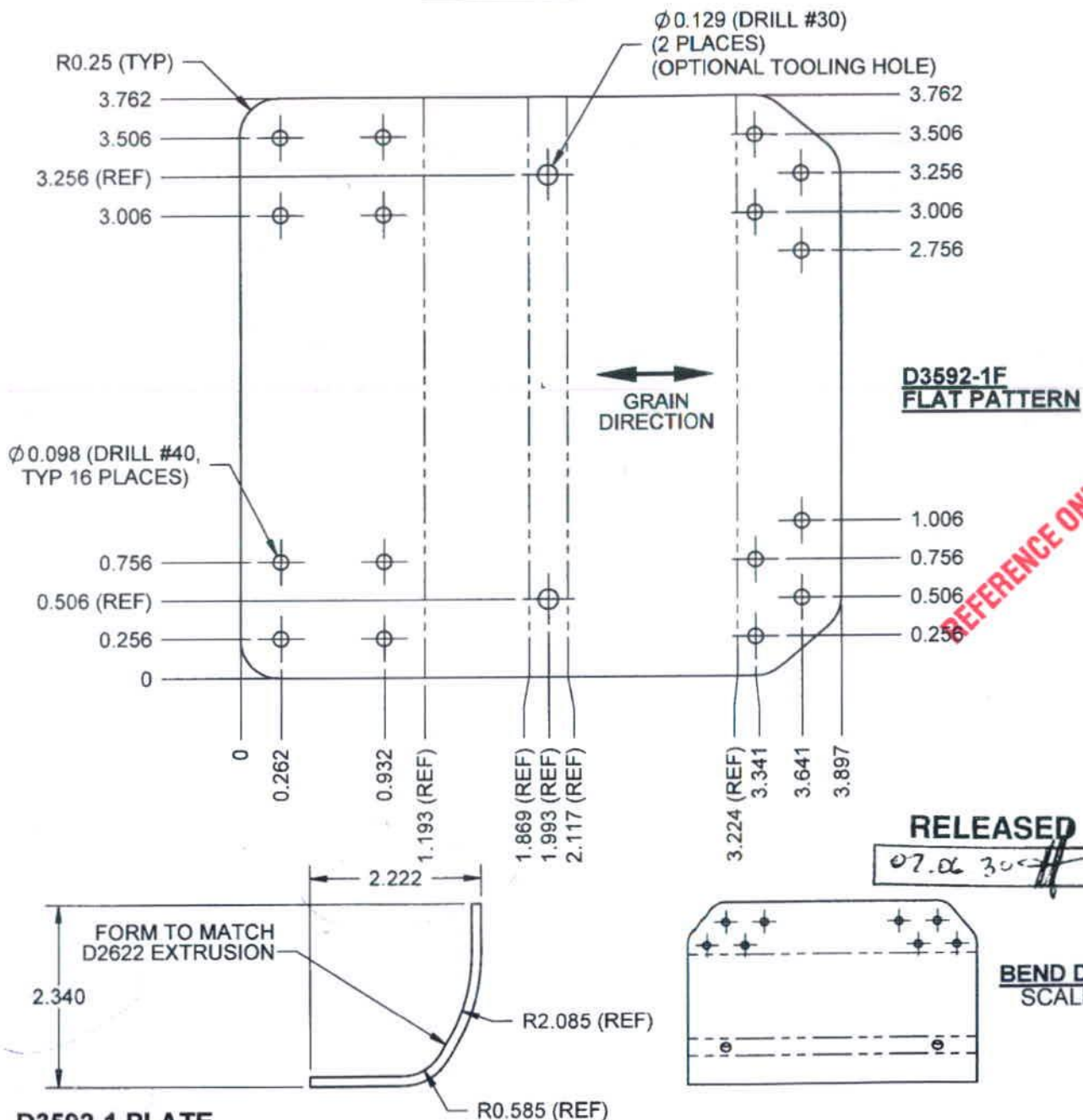
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN 9P	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 9P	APPROVED [Signature]	DRAWING NO. D3592	REV. B SHEET 1 OF 1
DATE 07.05.31	TITLE PLATE SCALE 1:1		
A	07.01.15	NEW ISSUE	
B	07.05.31	TOOLING HOLES ADDED	

**D3592-1 PLATE****NOTES:**

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